AMENDMENTS TO THE SPECIFICATION

Please replace the paragraph beginning at page 7, line 5, with the following rewritten paragraph.

-- Further, as the injection unit it is preferable to use a plunger type injection unit in which there is accommodated, for ~~every~~ the respective rubber parts, a rubber amount corresponding at least to the specification of the formed tire. Such a plunger type injection unit can precisely inject a required volume of unvulcanized rubber for ~~every~~ the respective rubber parts and, moreover, can easily change the require volume for every tire. --

Please replace the paragraph beginning at page 13, line 23, with the following rewritten paragraph.

-- That is, the inner liner servicer 60 and the carcass ~~serviser~~ servicer 70 are adapted such that they can respectively supply the inner liner 65 and the carcass 75 which are used in a tire having the same bead inner diameter corresponding to the specified band periphery length, and the cut dimensions of the inner liner and the carcass can be changed in compliance with an oblate ratio and a tread width of the formed tire. The inner liner 65 and the carcass 75 are adapted so as to be sequentially supplied to the band forming machine 10 through a carrying conveyor 66. The inner liner material 61 can be composed of a rubber and the like. Further, as the carcass material 71, it is possible to use a calender material rubberized by pulling together plural cords along a sheet longitudinal direction. --

Please replace the paragraph beginning at page 19 line 6, with the following rewritten paragraph.

-- As the aforesaid injection unit of the rubber parts servicers 80, 110, it is preferable to use a plunger type injection unit accommodating a rubber amount corresponding, for ~~every~~

the respective rubber parts, at least to a specification of the formed tire. FIG. 3 exemplifies the rubber parts servicer using the plunger type injection unit. As shown in FIG. 3, a plunger type injection unit 120 has a constitution in which a plunger 122 is slidably provided inside a cylindrical injection pot 121 and the plunger 122 is moved back and forth by a piston cylinder 124 extending from a hydraulic cylinder 123, and is adapted such that an unvulcanized rubber accommodated in the injection pot 121 is injected from a die 125. The plunger type injection unit 120 has advantages that it can precisely inject the unvulcanized rubber in a volume necessary for ~~every~~ the respective rubber parts and, moreover, can easily change a volume of the compounds necessary for every one tire.

Please replace the paragraph beginning at page 21, line 3, with the following rewritten paragraph.

-- FIG. 4(a) to FIG. 4(d) show forming processes of the band member. In the forming processes of a band member 140, the band drum 14 is first disposed to a position facing the rubber parts servicers 80 by moving the band forming machine 10 on the rails 55. And, the desired compounds are accommodated, for ~~every~~ the respective rubber parts, in the injection units 82 of the rubber parts servicers 80, corresponding to the rim cushion and the side wall, and the rubber strips supplied from the injection units 82 are wound around the band drum 14 while controlling the rotating speed of the band drum 14 and the traversing speeds of the rubber parts servicers 80. In this manner, a side wall 141 shown in FIG. 4(a) is formed at a position, in the band drum 14, corresponding to the specification of the formed tire and, additionally, a rim cushion 142 shown in FIG. 4(b) is formed.

Please replace the paragraph beginning at page 21, line 19, with the following rewritten paragraph.

-- Next, the desired compounds are accommodated, for ~~every~~ the respective rubber parts, in the injection unit 82 of the rubber parts servicers 80, corresponding to the belt edge

cushion, and the rubber strip supplied from the injection unit 82 is wound around a predetermined position of the carcass 75 on the band drum 14 while controlling the rotating speed of the band drum 14 and the traversing speed of the rubber parts servicer 80. In this manner, a belt edge cushion 143 shown in FIG. 4(d) is formed at a position corresponding to the specification of the formed tire. --

Please replace the paragraph beginning at page 25, line 12, with the following rewritten paragraph.

-- In the above tire forming system, so long as the tire has the same bead inner diameter, the stage switchover can be performed instantaneously. For example, as to the inner liner 65 and the carcass 75, the stage switchover is completed merely by changing the cutting lengths of the inner liner servicer 60 and the carcass servicer 70. As to the rubber parts for band, such as the side wall 141, the rim cushion 142 and the belt edge cushion 143, the stage switchover is completed merely by changing the setting of the rubber parts servicer 80. As to the completed bead 144, the stage switchover is completed merely by changing the selection of the bead servicer 90. As to the belt such as the 1st belt 151 and the 2nd belt 152, the stage switchover is completed merely by changing the setting of the belt servicer 100. As to the rubber parts for tread, such as the under tread 153 and the cap tread 154, the stage switchover is completed merely by changing the setting of the rubber parts servicer 110. And, since each of the above stage switchovers can be performed by means of an automatic control by a computer and the like, the stage switchovers of the whole system can be automatically performed instantaneously. As a result, the tire whose bead inner diameter is the same but which is different in its tire size, use and characteristics can be continuously formed in one unit. --